

AMENDMENTS TO THE SPECIFICATION:

Page 6

Please amend the fifth full paragraph as follows:

The invention also pertains to a chip removal machine 10, see Fig. 3, with a mechanical drive 6 for a tool 7 and/or a workpiece 1, regulated by a control system 5, wherein the regulation comprises a plurality of values C, X, Z of at least three spatial axes c, x, z for the control system 5 and for the drive 6, and the above-described method is used for determining the deviation of the regulating variables.

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Please amend the second, third and fourth full paragraphs on page 7 as follows:

BRIEF DESCRIPTION OF THE DRAWINGS

Additional benefits and details of the invention are discussed in the patent claims and in the specification, and presented in the figures. These show:

Figure 1, a representation of the differential values of a lens surface;

Figure 2, the representation of the z-value with the representation of the corresponding differential value; and[[.]]

Figure 3, one embodiment of a chip removal machine according to the present invention.

Please amend the full paragraph as follows:

List of reference symbols

- 1 workpiece
- 2 positive deviation
- 2.1 positive deviation of 1st degree
- 2.2 positive deviation of 2nd degree
- 2.3 positive deviation of 3rd degree
- 3 negative deviation
- 3.1 negative deviation of 1st degree
- 3.2 negative deviation of 2nd degree
- 3.3 negative deviation of 3rd degree
- 4 z-value
- 5 control system
- 6 mechanical drive
- 7 tool
- 10 chip removal machine